

Work Order ID 144786

April 22, 2016 4:27:24 PM

144786

Item ID: D3500-1

Accept

N900040100

Setup Start *NS1

Revision ID:

Item Name: Saddle

Stop *NS2

Start Date: 3/28/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 4/11/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: ujs Date: APR 25 2016

Tooling:

Date:

Run Start *NR1

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stam
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Draw Nbr	Revision Nbr
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D3500	C
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100

HAAS CNC VERTICAL MACHINING #1

0.15

100

HAAS 1

HAAS CNC vertical machine #1

Memo

8.40

Program Batch No. 144786 Double check by: 214 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets 2-Machine Step
No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA641 and inspect p

40

0

16-05-04
DAS
20
9-89
16-05-04

110

QC1- Inspection performed by CMM

0.00

QC2

110

QC

Quality Control

Memo

0.40

Inspect on CMM as per folio CMMA031.
DWG REV: _____
CMM PROG. REV: _____

40

0

16-05-04
DAS
20 16-05-04
9-89

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.80

40

0

16-05-04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	1.20							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140	M 134631								
Powdercoat	Memo	1.20							
Powder Coating	START TIME: 6.50 OVEN TEMPERATURE: 1700								
	FINISH TIME: 7.00								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.40							
Quality Control									

40 x 4 16/05/05

110 4 16-05-17 234 989

40 DAS 38 9-89 MAY 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>5406</u>	0.00							
160									
Packaging	Memo	0.40				40	DAS 6 3.89		
Packaging									MAY 17 2016
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	4.00							
Quality Control									MAY 17 2016

MCS MAY 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

April 22, 2016 4:27:24 PM

Page 1

Work Order ID: 144786

144786

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 3/28/2016

Required Date: 4/11/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	49.0000	1	40			

D6102-013

Saddle Billet

Location

Loc Qty

Loc Code

MAT046

49

138664

3

138975

26

139703

20

3
26
17

P 16-05-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Bending ☐	Set-up ☐	Folio/Program ☐																																																											
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐																																																											
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐																																																											
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐																																																											
Cuffs ☐	Contamination ☐	Out of Sequence ☐																																																											
Crushing ☐	Countersink ☐	Off-set ☐																																																											
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐																																																											
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐																																																											
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐																																																											
		OTHER : ☐																																																											

DART AEROSPACE LTD				Work Order: 144786	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.5005	.5005	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.590	1.591	1.589	1.585
J	0.240	0.260		.250	.246	.247	.250	.250
K	0.490	0.510		.500	.500	.500	.500	.500
L	3.590	3.650		3.650	3.650	3.650	3.625	3.625
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.001	6.002	6.001	6.001
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.549	.548	.551	.549	.5485
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.060	.05	.05	.05	.05
Y	0.100	0.120		.100	.105	.108	.105	.110
AA	R1.125	R1.145		1.135	1.137	1.1375	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.635	.625	.625	.625	.630
AD	0.240	0.260		.251	.247	.250	.252	.252
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.250	.250	.251	.251	.251
AG	0.140	0.160		.150	.150	.151	.151	.151
AH	0.140	0.160		.154	.151	.148	.147	.148
AI	0.140	0.160		.158	.154	.145	.148	.148

Accept/Reject

Measured by: 16-05-01	Date:
Audited by: SL	Date: 16-5-4
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 144786	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#6	#7	#8	#9	#10
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.376	.376	.375	.375
F	0.490	0.510	.288	.500	.500	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.5855	1.585	1.5845	1.585	1.5845
J	0.240	0.260		.250	.250	.250	.250	.250
K	0.490	0.510	.288	.500	.4985	.4985	.500	.500
L	3.590	3.650		3.625	3.625	3.625	3.625	3.625
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.001	6.001	6.001	6.001	6.001
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560	.548	.547	.548	.547	.549	.549
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.053	.055	.055	.055	.055
Y	0.100	0.120		.107	.105	.109	.108	.110
AA	R1.125	R1.145		1.1345	1.1325	1.134	1.135	1.134
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.630	.630
AD	0.240	0.260		.253	.253	.253	.253	.253
AE	1.810	1.830		1.820	1.820	1.820	1.815	1.815
AF	0.240	0.260		.251	.251	.251	.251	.251
AG	0.140	0.160		.151	.151	.151	.151	.151
AH	0.140	0.160		.148	.147	.146	.148	.148
AI	0.140	0.160		.150	.148	.148	.148	.148

Accept/Reject

Measured by: [Signature]	Date: 16-05-01
Audited by: [Signature]	Date: 16-54
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	[Signature]

DART AEROSPACE LTD				Work Order:	144786
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.495	.501	.500	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.5845	1.587	1.583	1.5845	1.5816
J	0.240	0.260		.251	.251	.251	.250	.249
K	0.490	0.510		.5005	.500	.500	.500	.500
L	3.590	3.650		3.630	3.630	3.630	3.630	3.630
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.001	6.001	6.001	6.002	6.001
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.547	.547	.550	.550	.551
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.05	.05	.054	.054	.050
Y	0.100	0.120		.110	.110	.110	.108	.110
AA	R1.125	R1.145		1.134	1.133	1.132	1.1343	1.137
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.253	.253	.2535	.2505	.250
AE	1.810	1.830		1.819	1.8195	1.8195	1.8195	1.824
AF	0.240	0.260		.251	.250	.249	.250	.251
AG	0.140	0.160		.150	.150	.149	.154	.1515
AH	0.140	0.160		.148	.148	.149	.148	.146
AI	0.140	0.160		.149	.148	.149	.149	.148

Accept/Reject

Measured by:	16-05-02	Date:	
Audited by:	SL	Date:	16-5-4
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 144786	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	217	218	219	220
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510	.258	.500	.500	.501	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.5865	1.583	1.584	1.586	1.5845
J	0.240	0.260		.253	.252	.249	.249	.250
K	0.490	0.510	.258	.500	.500	.499	.500	.500
L	3.590	3.650		3.630	3.630	3.630	3.630	3.630
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.001	6.001	6.001	6.001	6.002
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560	.421	.548	.549	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.05	.05	.05	.05	.05
Y	0.100	0.120		.110	.110	.110	.110	.105
AA	R1.125	R1.145		1.132	1.133	1.1335	1.1345	1.134
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.253	.2535	.252	.252	.252
AE	1.810	1.830		1.821	1.820	1.8195	1.819	1.819
AF	0.240	0.260		.249	.250	.250	.250	.250
AG	0.140	0.160		.149	.150	.150	.149	.149
AH	0.140	0.160		.148	.148	.148	.148	.148
AI	0.140	0.160		.156	.150	.150	.148	.148
Accept/Reject								

Measured by: 16-05-02	Date:
Audited by: S	Date: 16-5-4
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 144786	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21	22	23	24	25
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510	.258	.500	.500	.500	.501	.494
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.586	1.585	1.588	1.585
J	0.240	0.260		.250	.249	.250	.247	.248
K	0.490	0.510	.258	.500	.500	.500	.500	.497
L	3.590	3.650		3.630	3.630	3.630	3.630	3.630
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.258	.258	.258	.258	.258
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.001	6.001	6.002	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560	.421	.549	.548	.549	.548	.548
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.05	.05	.05	.042	.050
Y	0.100	0.120		.107	.110	.110	.110	.105
AA	R1.125	R1.145		1.134	1.135	1.135	1.135	1.133
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.630	.630	.630	.615	.627
AD	0.240	0.260		.2525	.251	.252	.249	.250
AE	1.810	1.830		1.821	1.8195	1.820	1.820	1.820
AF	0.240	0.260		.250	.250	.250	.250	.249
AG	0.140	0.160		.150	.150	.150	.150	.149
AH	0.140	0.160		.146	.149	.150	.147	.147
AI	0.140	0.160		.149	.146	.148	.145	.148

Accept/Reject

Measured by: <i>[Signature]</i> 16-05-02	Date: 20 16-05-03
Audited by: <i>[Signature]</i>	Date: 16-5-4
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD				Work Order: 144786	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				# 26	# 27	# 28	# 29	# 30
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.495	.496	.496	.498	.498
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.247	.247	.247	.247	.248
K	0.490	0.510		.498	.498	.499	.500	.498
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.259	.259	.259	.259	.259
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.548	.547	.549	.548
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.105	.105	.105	.105	.105
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.627	.627	.627	.627	.627
AD	0.240	0.260		.249	.248	.250	.249	.249
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.249	.249	.248	.247	.248
AG	0.140	0.160		.149	.151	.150	.148	.148
AH	0.140	0.160		.145	.144	.144	.146	.146
AI	0.140	0.160		.149	.150	.145	.145	.145

DA Accept/Reject

Measured by: 20 9-09 16-05-03	Date:
Audited by: J	Date: 16-5-4
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 44786	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				31	32	33	34	35
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.499	.499	.499	.4985	.497
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.247	.248	.247	.246	.245
K	0.490	0.510		.499	.499	.499	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.259	.259	.259	.259	.259
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.548	.548	.549	.548	.546
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.105	.105	.105	.105	.105
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.627	.627	.627	.627	.627
AD	0.240	0.260		.249	.249	.250	.250	.251
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.248	.247	.247	.247	.247
AG	0.140	0.160		.149	.148	.149	.148	.148
AH	0.140	0.160		.146	.144	.144	.144	.144
AI	0.140	0.160		.146	.144	.145	.144	.145

DA Accept/Reject

Measured by: 20 9-00 116-05-03	Date:
Audited by: J	Date: 16-5-4
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 144786	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				# 36	# 37	# 38	# 39	# 40
A	0.483	0.490		.485	.485	.485	.485	.485
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.498	.499	.4985	.498	.4975
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		.246	.247	.248	.248	.248
K	0.490	0.510		.4985	.500	.500	.500	.499
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.259	.259	.259	.259	.259
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.546	.548	.548	.545	.548
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.105	.105	.105	.105	.105
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.627	.627	.627	.627	.627
AD	0.240	0.260		.250	.251	.250	.250	.249
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.247	.248	.247	.249	.248
AG	0.140	0.160		.148	.148	.148	.151	.150
AH	0.140	0.160		.145	.145	.146	.146	.145
AI	0.140	0.160		.144	.146	.146	.144	.145

DAA Accept/Reject

Measured by: 20 9.89 16-05-03	Date:
Audited by: J	Date: 16-5-4
Preliminary Approval:	Date:

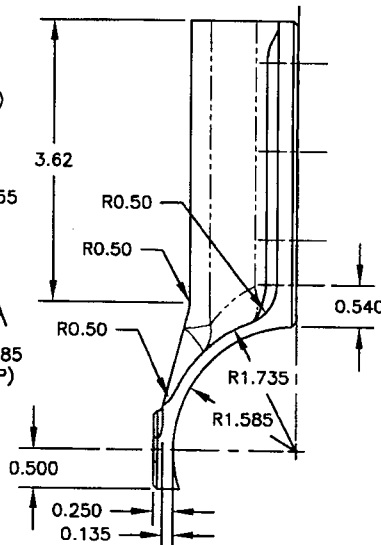
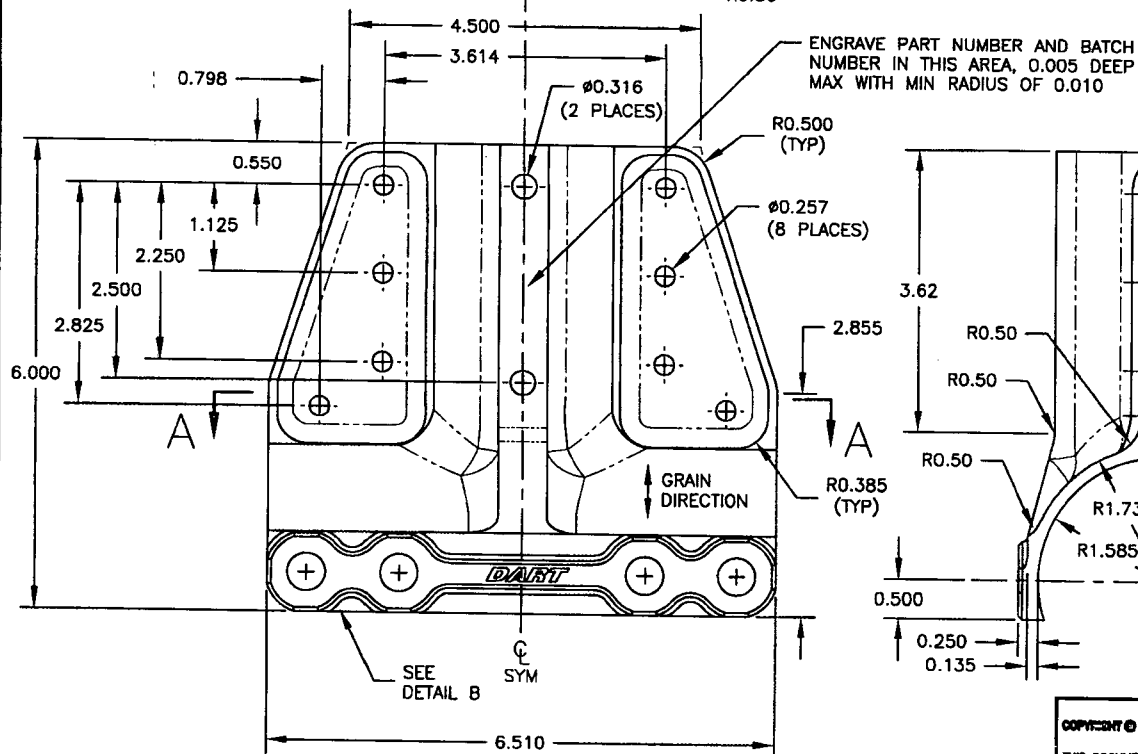
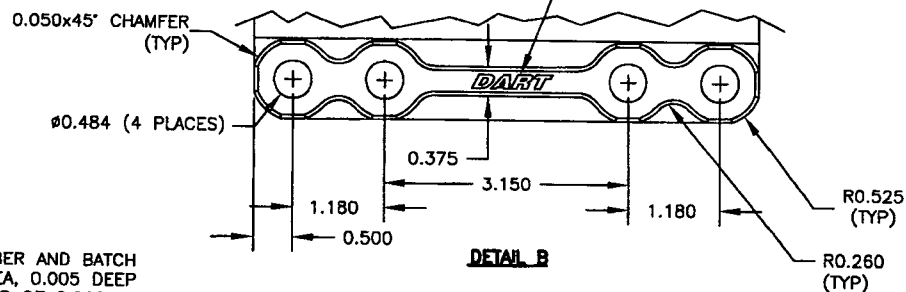
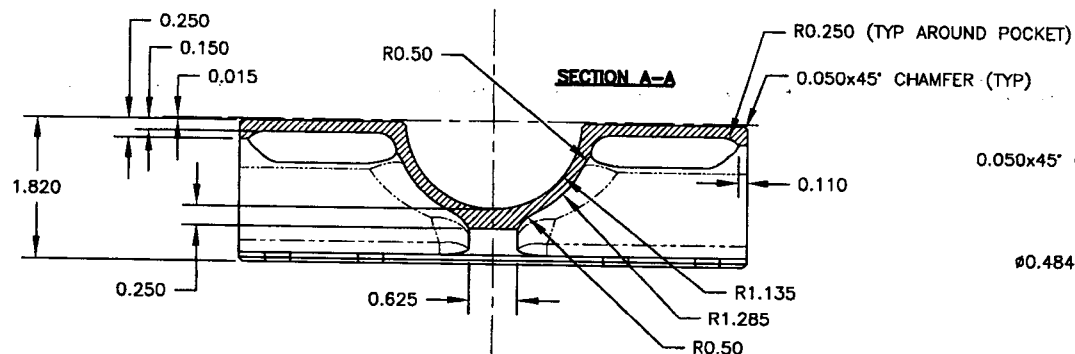
Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

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WITHOUT NOTICE
WORK ORDER
NO. 144786 M.C.S.

16-04-25

ENGRAVE DART LOGO IN
THIS AREA TO A MAX
DEPTH OF 0.015 AND A MIN.
TOOL RADIUS OF 0.250



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15 #

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	PH	DART DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3500
DATE	06.06.30	TITLE SADDLE
		REV. C SHEET 1 OF 1 SCALE 2:3

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